

Work Order ID 54653

December 15, 2009 1:44:46 PM

SHIP 2/12!



Page 1

Item ID: D130-700-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 12/15/09 Start Qty: 3.00



Cust Item ID:

Required Date: 12/21/09 Req'd Qty: 3.00



Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

D3167

Rev A1

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D130-700-011CHG001

120

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

Cut Blank as per File D3167-1\_BLANK

130

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

Note: (2) Bearpaw for (1) Kit 1-1-Inspect material for defects or damage prior to machining. 2-Machine as per Folio FA285 and Dwg D3167 3-Deburr

for CL 09/12/21

B 9-12-15

6

DA 09/12/17

6

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Required Date: 12/21/09 Req'd Qty: 3.00

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Accept



Setup Start



Stop



Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

140

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*DJP 09/12/17*

*(6)*

150

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*smk 09/12/21*

*(6)*

160

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

*al/2/21* *(25)*

**Work Order ID 54653**

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Page 3

Item ID: D130-700-011

Accept



Setup Start



Revision ID:

Stop



Item Name: Bearpaw

Start Date: 12/15/09 Start Qty: 3.00



Cust Item ID:

Required Date: 12/21/09 Req'd Qty: 3.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

170

QC4- 100% Inspect kits for completeness

0.00



3

12.12.21

QC

Memo

0.00

Quality Control

180

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D130-700-011. Location: \_\_\_\_\_

Rev A

9/12/21

(34) \$

190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/12/21

12.12.21

# Picklist Print

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Work Order ID: 54653

Parent Item: D130-700-011

Parent Item Name: Bearpaw



Comments:

Start Date: 12/15/09

Required Date: 12/21/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-12A  Bolt	x4	Purchased	No			170	Each	436.0000	12.0000 	9/10/20	SP	

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

436

105143

1

111605

13

111925

87

112314

300

6071

35

170

Each

158.0000

24.0000  


18

9/10/21 SP (30)

AN4-15A  
  
Bolt

Purchased

No

Warehouse  
Location

Loc Qty

Loc Code

Main Warehouse

ST

158

113121

158

24

# Picklist Print

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Work Order ID: 54653

Parent Item: D130-700-011

Parent Item Name: Bearpaw


Comments:

Start Date: 12/15/09

Required Date: 12/21/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN960JD416  Washer DAS1149 004631		Purchased	No			170	Each	1,773.000	36.0000		11/09/14 9/10/21	SP

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST	1773
103691	20
104215	6
108161	329
110523	340
111279	101
111916	482
112314	495
16941	0

D2182B  Rubber Cushion (2182-060) (4) 6.00"	Manufactured	No				170	f	357.2160	6.0000		9/10/21	SP
--	--------------	----	--	--	--	-----	---	----------	--------	--	---------	----

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST	57.216
28042	7.33
30872	0.33
45405	49.556

Main Warehouse

ST410	300
52649	300

1/2 each

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Shop Packet Print

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# Picklist Print

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Work Order ID: 54653

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Parent Item Name: Bearpaw

Comments:

Start Date: 12/15/09

Required Date: 12/21/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D2274 Radius Block		Manufactured	No			170	Each	217.0000	36.0000			

9/16/12 SP

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST  
52644

217

217

170

Each

68.0000

12.0000

30

9/16/12

SP

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST  
43842

68

68

170

Each

922.0000

36.0000

10

9/16/12

(34) SP

Warehouse Loc Qty Loc Code  
Location

Main Warehouse

ST  
52745

922

922

30

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Page 3

# Picklist Print

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Page 4 *5*

Work Order ID: 54653

Parent Item: D130-700-011

Parent Item Name: Bearpaw



Comments:

Start Date: 12/15/09

Required Date: 12/21/09

Start Qty: 3.00

Required Qty: 3.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D3171-1  Angle	<i>x4</i>	Manufactured	No			170	Each	26.0000	<i>12</i> 12.0000 	<i>9/12/01</i>	<i>sl</i>	

Warehouse Loc Qty Loc Code

Location

Main Warehouse

ST

26

*51410*

26

170

Each

4,847.000

*12*  
36.0000  


*12*

*9/12/01*

*sl 34*

MS21042L4

Purchased

No

Nut

*x12*

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

4847

102552

6

104248

6

110507

184

*11827*

3651

113422

1000

15924

0

*30*

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# Picklist Print

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Work Order ID: 54653

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Parent Item Name: Bearpaw

Comments:

Start Date: 12/15/09

Required Date: 12/21/09

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Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

MUHMWB10

Purchased

No

120

sf

383.3041

21.5368



UHMW 1" Black

*189-12-15*

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	341.2164	
112186	122.0164	
112514	11.2	
113166	208	
Main Warehouse		
ST	42.0877	
111354	42.0877	

\_\_\_\_\_  
112514 X 3  
\_\_\_\_\_  
\_\_\_\_\_

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Shop Packet Print

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DART AEROSPACE LTD		Work Order: 54653
Description: Bearpaw		Part Number: D3167-1
Inspection Dwg: D3167	Rev: A1	Page 1 of 1

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

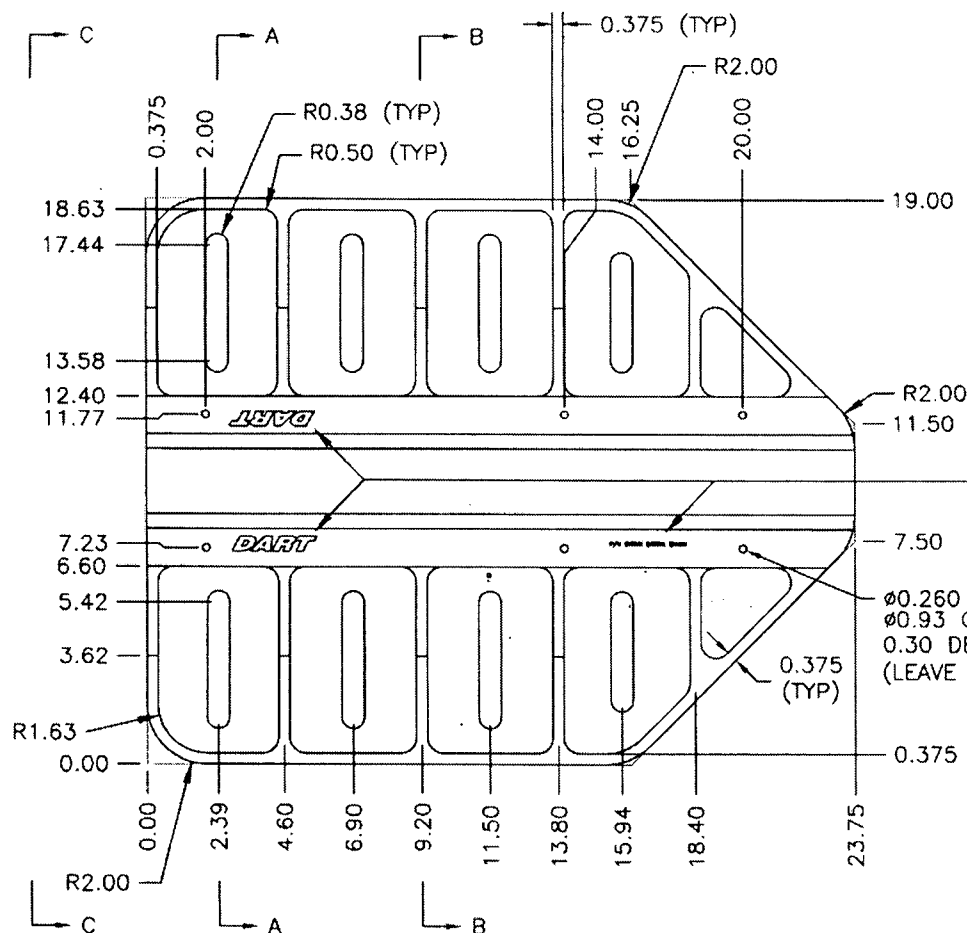
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B	5.80	+/-0.030	5.800	✓			
C	0.25 x 45°	+/-0.030	0.25 x 45°	✓			
D	R0.25	+/-0.030	0.250	✓			
E	0.200	+/-0.030	0.200	✓			
F	0.250	+/-0.010	0.248	✓			
G	0.625	+/-0.030	0.620	✓			
H	0.375	+/-0.010	0.377	✓			
I	0.950	+0.030/-0.010	0.960	✓			
J	3.21	+/-0.030	3.210	✓			
K	19.00	+/-0.030	19.00	✓			
L	Ø0.260	+0.005/-0.000	0.260	✓			
M	Ø0.93	+/-0.030	0.923	✓			
N	0.30	+0.030/-0.000	0.310	✓			
O	0.375	+/-0.030	0.380	✓			
P	7.23	+/-0.030	7.230	✓			
Q	4.54	+/-0.010	4.540	✓			
R	2.00	+/-0.030	2.00	✓			
S	12.000	+/-0.010	12.00	✓			
T	6.000	+/-0.010	6.00	✓			
U	23.75	+/-0.030	23.75	✓			

Measured by: DJP	Audited by: [Signature]	Prototype Approval: N/A
Date: 09/12/17	Date: 09/12/17	Date: N/A

Rev	Date	Change	Revised by	Approved
A	03.09.22	New Issue P/O D130-700-011	KJ/RF	[Signature]



DESIGN		DRAWN BY		DART AEROSPACE LTD	
CHECKED		APPROVED		DRAWING NO.	
DATE		TITLE		D3167	
02.10.08		BEARPAW		NEW ISSUE	
A		02.10.08		1:6	
A1		02.12.17		5.80	
				17.1	



D3167-1

MATERIAL: UHMW BLACK PER SPEC CONTROL DRAWING D2689  
1.00 THICK (MACHINE TO 0.950)  
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

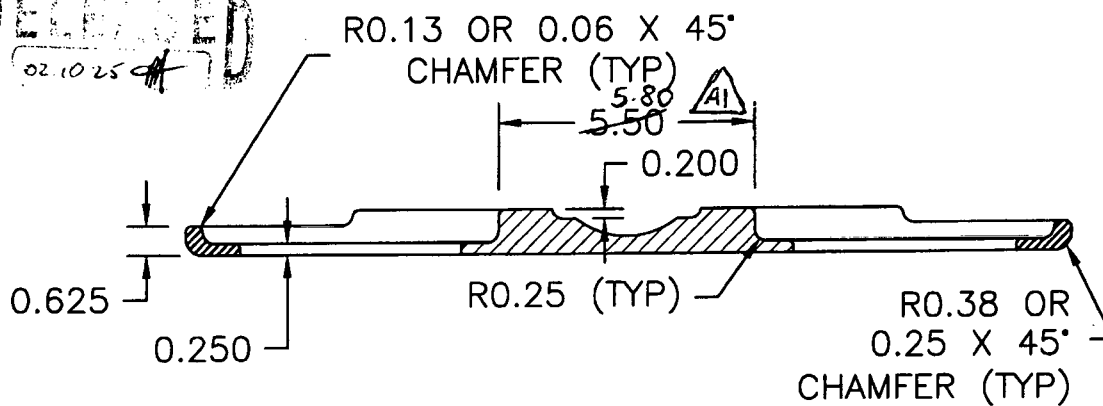
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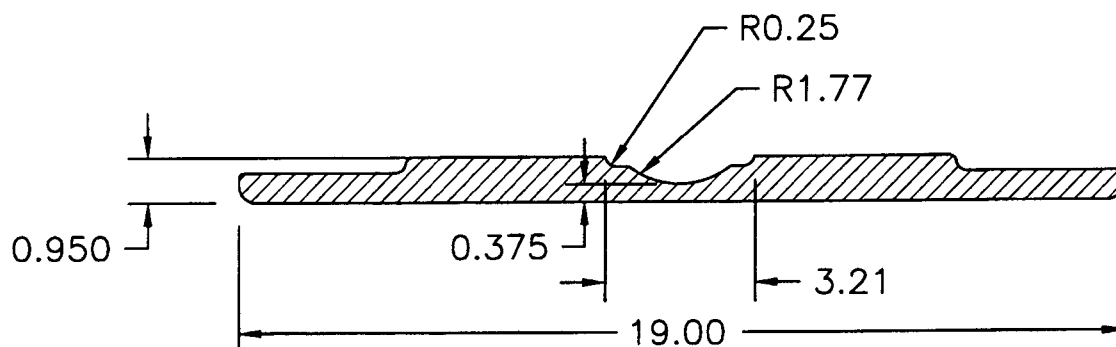


DESIGN 	DRAWN BY 	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED 	APPROVED 	DRAWING NO. D3167	REV. A SHEET 2 OF 2
DATE 02.10.08		TITLE BEARPAW	SCALE 1:4

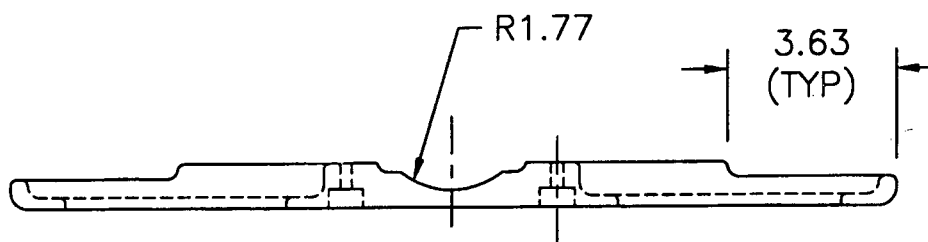
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02.10.25



SECTION A-A



SECTION B-B



SECTION C-C

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